

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004208**Date Inspected:** 24-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhang Bao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Assembly**Summary of Items Observed:**

This report serves to document the events occurring on this date at the following location. Caltrans Quality Assurance (QA) Inspector Robert Vatcher arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

**OBG Assembly Bay II**

QA was tasked with performing welding operation monitoring at locations where diaphragm plates are being joined to deck panels specifically DP061-001 and DOP062-001. QA observed for this operation the FCAW process utilizing 1.4 mm diameter Supercored 71H E71T-1 electrode wire in DCEP mode. Welder Wu Wanyong 050242, a qualified welding operator was observed as well utilizing a weave bead method for this evolution however is not listed on the welding procedure specification WPS-B-T-2233-TC-U4B-F nor the associated PQR. QA measured amperage to be 205 (average), voltage at 25.5 constant and a travel speed of 107 mm per minute however utilizing the weave bead method.

The above mentioned items as observed, corrected by contractor QC & documented by QA appear to conform to the contract documents.

**Summary of Conversations:**

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No relevant conversations this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco 138-1694-2685, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Vatcher,Robert
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Cuellar,Robert
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QA Reviewer
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